

Date: Monday, 4/10/2006 11:14:43 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACER RING
Job Number	: 26619		
Estimate Number	: 12176		
P.O. Number	: N/A	Part Number	: D34765
This Issue	: 4/10/2006 S.O. No. : N/A	Drawing Number	: D3476 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: A
Previous Run	: 26281	Material	: N/A
Written By	SEE COMMENT BELOW	Due Date	: 4/28/2006
Checked & Approved By	06.04.10	Qty:	10
Comment	: Est Rev: A New Issue 06-02-03 JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: Issue P/O: 1042
 E-mail or Ship DXF file to vendor
 Laser cut flat pattern as per Dwg D3476
 Possible supplier: Ind. Laser
 Material release note is required.

06/04/28

268

2.0	D34765F	SPACER RING, FLAT PATTERN
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 FLANGE PLATE

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Receive & Inspect For Transit Damage
 Ensure material certification is attached

06/04/28

(10)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

06.05.02

10

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if necessary.

2-Roll as per Dwg D3476

06/05/19

10

H.M 06/05/03 (10)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LP Date: 06/06/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/10/2006 11:14:43 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER RING

Job Number: 26619

Part Number: D34765

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



2060523

Comment: INSPECT WORK TO CURRENT STEP

7.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub Contracting OUTSIDE SERVICES

Issue P/O:

Electro Chemically Polish weldment as per Dwg D3476

Ensure Certificate of Conformity is attached

N/A

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

N/A

20616601

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

442

20616601 10

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

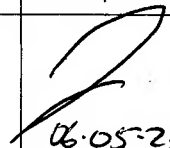
20616602 10

Job Completion



20616602

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-05-23	7 8	No electro polish req'd. remove step. Add polish with blue pad.				W	 06-05-23

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

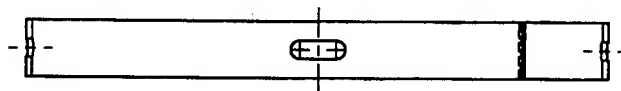
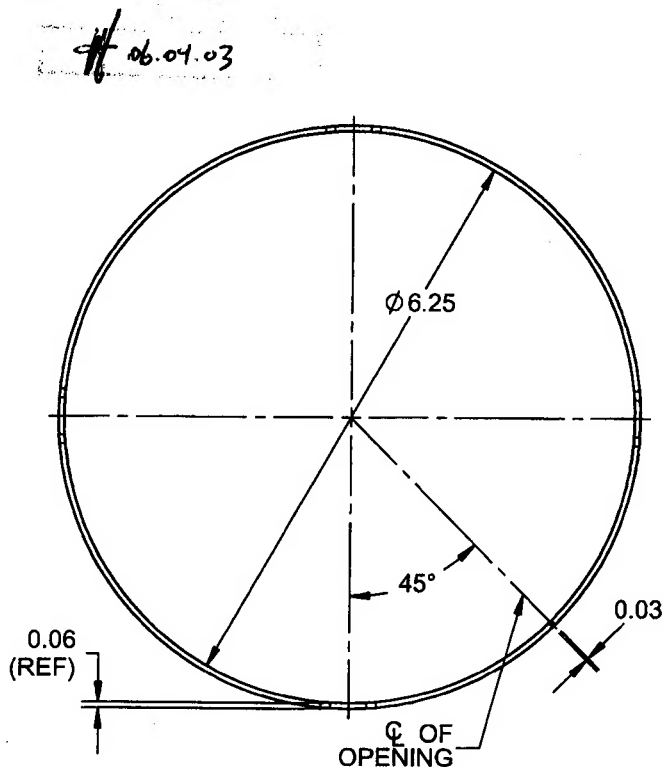
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

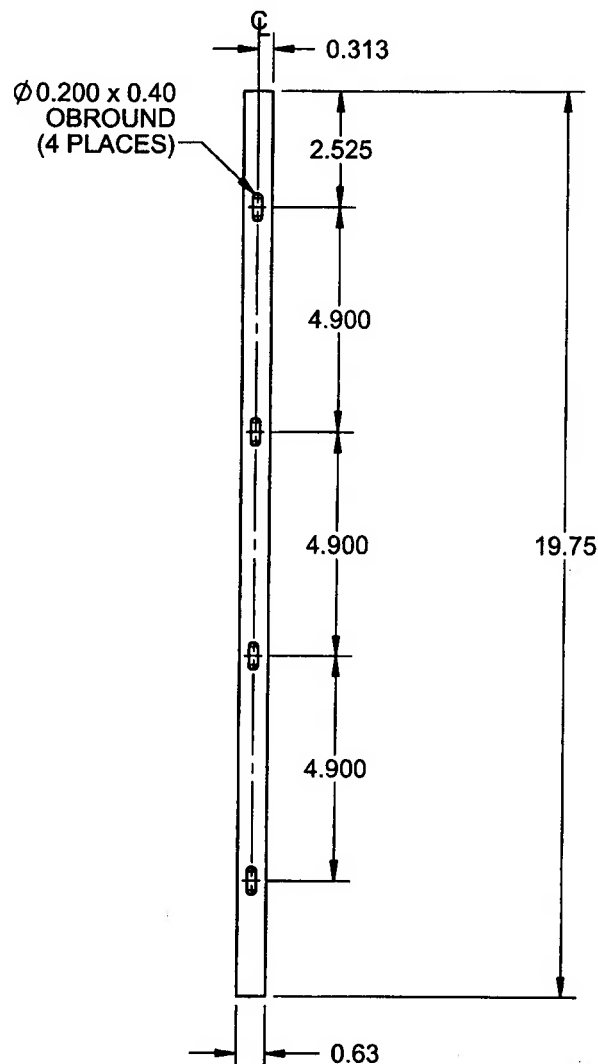
NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3476	REV. A SHEET 6 OF 7
DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	SCALE 1:2



D3476-5 SPACER-RING



**D3476-5F SPACER-RING
FLAT PATTERN**

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.063 THICK, PER MIL-S-5019 (ANNEALED), 2B FINISH (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *26619*

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P51219PC002

METALLURGICAL TEST REPORT

NORTH AMERICAN STAINLESS CANADA, INC.
740 IMPERIAL ROAD NORTH
GUELPH, ON N1E 1Z3

NORTH AMERICAN STAINLESS CANADA, INC.

Certificate: 6511 3 Mail To:
WILKINSON STEEL AND METALS
089 SOUTHEAST DRIVE
VANCOUVER, BC V5X2V3

Ship To:
WILKINSON STEEL AND METALS
188 SOUTHEAST DRIVE
VANCOUVER, BC V5X2V3

Date: 3/14/2006 Page: 1

Steel: 304

Finish: 2B

Corrosion: ASTM A262/02a, 1508end-OK

Your Order: P51219PC002

NAS Order: IN 0006074 01

PRODUCT DESCRIPTION:

STAINLESS STEEL SHEET, COLD ROLLED, ANNEALED AND PICKLED.
ASTM A240/05a, 480/05, 666/03, ASME SA240/04-A05, 480/04-A05, SA666/04
Q98765D-A X NO PPM, AMS 5513H X MARKER PIN, MIL 5059D, AND 3, X CROWN MEAS

REMARKS:

Material free from mercury contamination. No weld repairs.
EN 10204 3.1 PED 97/23/EC Annex 1, Para. 4.3 Q98765D Cond A
Material is RoHS-Compliant

Product Id	Coil #	Thickness	Width	Weight	Length	Mark	Pieces	Commodity Code
B44828	B44828	.0173	48.0000	2,460 SHEETS	096.00	2	108	

CHEMICAL ANALYSIS CM(Country of Melt) ES(Spain) US(United States)

Heat	CM	C	CR	CU	MN	MO	N	NI	P	S	SI
89T1	US	.046	18.306	.391	1.671	.337	.052	8.161	.029	.001	.235

MECHANICAL PROPERTIES

Product Id#	Coil #	Id Coil	UTS KSI	.2% YS KSI	ELONG %-2"	Tail Hard	Hard R45T
B44828	0489T1	FT	102.19	54.50	57.72	54.00	55.50

SP
06/04/28

QC ENGINEER

3/14/2006

03/23/2006 03:26

15023476424

NOS

PAGE 00014

MATERIAL TEST/INSPECTION CERTIFICATE



YIEH MAU CORP.

INVOICE NO. : F05MB11

COMMODITY : PRIME COLD ROLLED STAINLESS STEEL SHEET

SPECIFICATION : AISI 304

CUSTOMER : INTEGRIS METALS LTD.

工廠:高雄美芝路竹園酒安路345M
345, SHUN AN RD. LU CHU NSLANG
KAHSUNG TAIWAN R.O.C.
TEL:(07)6972385 FAX:(07)6973006
CERTIFICATE NO. F05MB11
DATE OF ISSUE:1230/2005
PAGE:2/3

90270957

ITEM NO.	SIZE	NO.	Weight (N.W.)		Heat No.	ID NO.	Physical Properties					Chemical Composition							
			KGS	LBS			Tensile Test GL=50 mm			HV	C	Si	Mn	P	S	Ni	Cr	N	
							Y.S. (N/mm ²)	T.S. (N/mm ²)	EL. (%)										(%)
AISI 304, NO.4 (SIC) FINISH, WITH 100 MIC. FILM ON MAIN SIDE, WITH BACK-PASS, SLITTED EDGE.																			
7426-3530	18GA\48"X144"	1	1,435	3,164	YU139523	4BS18584-12	296	655	53	83	164	4.6	51	99	33	8	805	1856	2.2
7426-3539	18GA\60"X120"	1	1,424	3,139	YU137544	4BS18468A-11	308	701	50	88	165	4.7	50	117	31	5	804	1815	3
7426-8159	16GA\48"X 96"	1	1,445	3,186	YU189710	4BS18697-14	297	639	52	84	168	3.6	49	110	34	3	812	1818	3.2
7426-6159	16GA\48"X 96"	1	1,445	3,186	YU139710	4BS18697-15	297	639	52	84	168	3.6	49	110	34	3	812	1818	3.2
7426-6169	16GA\48"X 96"	1	1,445	3,186	YU139710	4BS18697-15	297	639	52	84	168	3.6	49	110	34	3	812	1818	3.2
7426-6288	16GA\48"X120"	1	1,462	3,223	YU139710	4BS18697-17	297	639	52	84	168	3.6	49	110	34	3	812	1818	3.2
7426-6288	16GA\48"X120"	1	1,462	3,223	YU139710	4BS18697-18	297	639	52	84	168	3.6	49	110	34	3	812	1818	3.2
7426-6343	16GA\60"X 96"	1	1,440	3,175	YU140033	4BS18975B-11	295	674	51	84	168	3.8	49	116	32	11	805	1804	2.7
7426-6353	16GA\60"X120"	1	1,418	3,126	YU140033	4BS18975B-16	295	674	51	84	168	3.8	49	116	32	11	805	1804	2.7
7426-6353	16GA\60"X120"	1	1,195	2,635	YU140033	4BS18975B-17	295	674	51	84	168	3.8	49	116	32	11	805	1804	2.7
7426-6363	16GA\60"X144"	1	1,376	3,031	YU140033	4BS18975B-12	295	674	51	84	168	3.8	49	116	32	11	805	1804	2.7
7426-9049	14GA\48"X120"	1	1,426	3,144	YU140207	4BS20605A-11	314	704	49	86	175	5.5	51	125	35	9	808	1818	1.8
7426-9049	14GA\48"X120"	1	1,421	3,133	YU140207	4BS20605A-12	314	704	49	86	175	5.5	51	125	35	9	808	1818	1.8
7426-9265	14GA\60"X120"	1	1,442	3,179	YU140018	4BS19451A-11	306	673	50	85	173	4.9	47	118	32	10	804	1830	2.8
7427-4844	12GA\48"X120"	1	1,362	3,003	YU235779	4BS18646A-113	308	641	53	84	166	4.6	48	118	35	4	814	1823	3.4
7427-4844	12GA\48"X120"	1	1,362	3,003	YU235779	4BS18646A-114	308	641	53	84	166	4.6	48	118	35	4	814	1823	3.4
7427-7166	11GA\48"X 96"	1	1,473	3,247	YU140191	4BS20468A-113	300	673	52	84	167	4.8	53	127	32	5	804	1806	3.1
7427-7166	11GA\48"X 96"	1	1,473	3,247	YU140191	4BS20468A-114	300	673	52	84	167	4.8	53	127	32	5	804	1806	3.1
7427-7177	11GA\48"X120"	1	1,308	2,884	YU236346	4BS20446B-115	293	655	51	83	162	4.1	49	124	33	7	810	1817	3
7427-7177	11GA\48"X120"	1	1,313	2,895	YU236346	4BS20446B-116	293	655	51	83	162	4.1	49	124	33	7	810	1817	3
7427-7177	11GA\48"X120"	1	1,312	2,892	YU236346	4BS20446B-117	293	655	51	83	162	4.1	49	124	33	7	810	1817	3
7427-7177	11GA\48"X120"	1	1,316	2,901	YU140191	4BS20468B-211	300	673	52	84	167	4.8	53	127	32	5	804	1806	3.1
7427-7177	11GA\48"X120"	1	1,316	2,901	YU140191	4BS20468B-212	300	673	52	84	167	4.8	53	127	32	5	804	1806	3.1
7426-3420	18GA\36"X144"	1	1,453	3,203	YU235224	4BS20614-114	306	662	54	84	168	4.2	52	128	33	8	802	1815	3.3
7426-3420	18GA\36"X144"	1	1,453	3,203	YU235224	4BS20614-115	306	662	54	84	168	4.2	52	128	33	8	802	1815	3.3

28 39 285 98.499

REMARKS: NO MERCURY CONTAMINATION

Bend tested for all Heat NO.

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS
BEEN MADE IN ACCORDANCE WITH THE RULES OF THE MILL CERTIFICATE.

- PRIME MATERIAL NO DINGS, NO DENTS, NO SCRATCHES
- P.O. NO. 407631 (VANCOUVER)
- SALES CONTRACT NUMBER: F05MB11
- DOCUMENTARY CREDIT NUMBER: ILCMP000165

YIEH MAU CORP.

Lin Kuo Hsing
Manager of Quality Assurance

PO 442

AS
06/04/28